

# Work Order ID 63702

November 10, 2010 10:52:14 AM

Page 1

Item ID: D212-725-1-231

Accept

Setup Start

Revision ID:

Stop

Item Name: Stiffener Angle

Start Date: 11/10/10 Start Qty: 2.00

Required Date: 11/15/10 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D212-725-1

F

100

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut as per dwg

2-Make radius as pre dwg and deburr

⇒ M-L 10/11/16

(2X)

10/11/15

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/15/16

(42)

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 BR 10-11-17

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Page 2

Item ID: D212-725-1-231

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Item Name: Stiffener Angle

Start Date: 11/10/10 Start Qty: 2.00

Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 386

0.00



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

=) M 10/11/17 24

10/11/17 2

OK 10/11/17 2

# Picklist Print

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Page 1

Work Order ID: 63702



Parent Item: D212-725-1-231



Parent Item Name: Stiffener Angle

Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.10.28 as per dwg revF DD verf:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A1.0X1.5X12 5		Purchased	No			100	f	12.0000	1.542	3.246316			



Angle 2024T3511 1.0x1.50x .125w



M-L 10/11/15

Location

Loc Qty

Loc Code

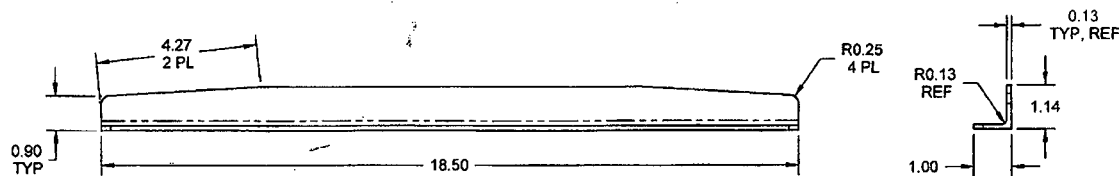
MAT

12

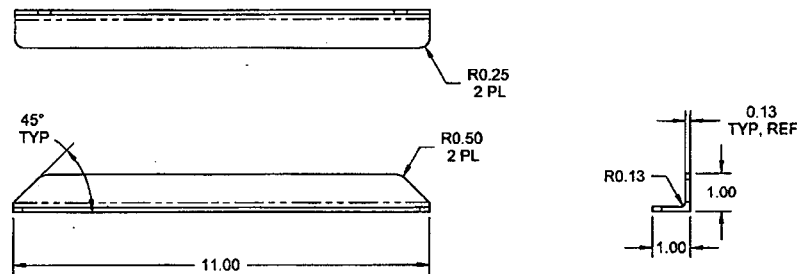
116085 ✓

12

3-246316



**D212-725-1-231 STIFFENER ANGLE**



**D212-725-1-233 STIFFENER ANGLE**

**D212-725-1-231/233 NOTES:**

- 1) MATERIAL: 2024-T3511 (QQ-A-200/3F) ANGLE EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D212-725-1-231/-233 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		D212-725-1	SHEET 81 OF 84
APPROVED		TITLE	SCALE
DE APPR.		212S DETAIL PARTS	NTS
DATE	09.02.02	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN THAT FOR WHICH IT WAS ISSUED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

**RELEASED**  
01/04/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries